

Work Order ID 74063

Wednesday, September 21, 2011 9:59:56 AM



Page 1

Item ID: D3303-1

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 9/22/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 11-09-21

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3303	Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

2024 .030

Memo

1-Cut as per Dwg D3303
Deburr if necessary Dwg Rev: *B* Prog Rev: *B* 2-*B11-9-28**10*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

0.00

B11-9-28

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

*8 Mor/26**7/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



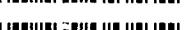
QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



HandFinish

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10 BL 11-9-28.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10X SP M 11/09/28

150



Packaging

Packaging

Identify as per dwg & Stock Location: ST 185

0.00

SP

10x

SP 11-09-28

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Page 3

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Start Date: 9/22/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/10/13 HJ

MF 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 9:59:53 AM

Page 1

Work Order ID: 74063



Parent Item: D3303-1



Parent Item Name: Plate

Start Date: 9/22/2011

Required Date: 10/7/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A 04.09.07 New issue KJ/JLM
IPP Rev:B 06-06-28 Now On Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 		Purchased		No		100	sf	137.2000	0.3542	2.982737	 FB11-9-28	3.5	

2024-T3 .032 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT22	137.2	
118243	41.2	
118523	96	

118243

(C)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74063
Description: Plate	Part Number:	D3303-1
Inspection Dwg: D3303	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-9-29</u>	Date: <u>Mar 28</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	07.01.16	5.00 was 5.000; Ø0.129 added	KJ/JLM	

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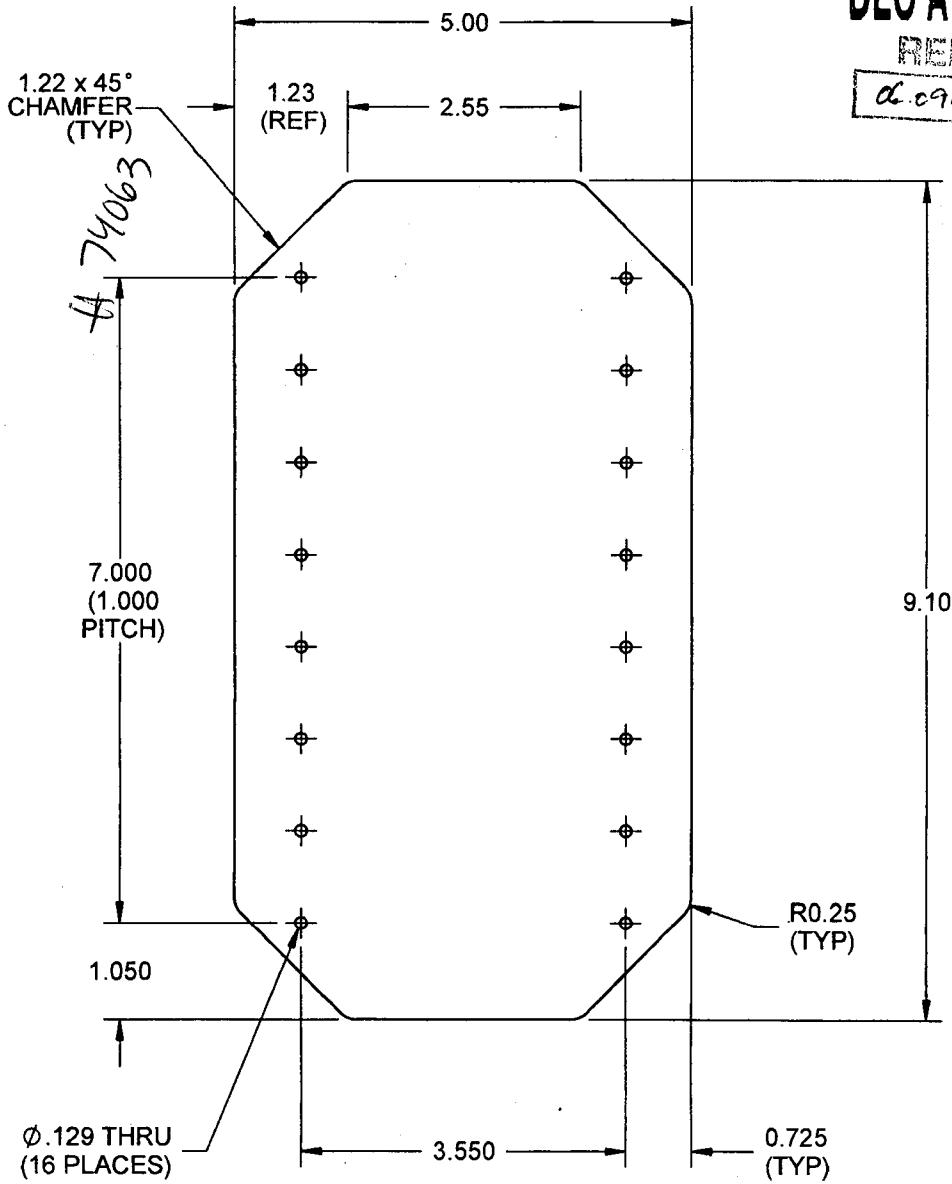
NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303
DATE 06.08.17	TITLE HEAD REST	REV. B SHEET 3 OF 4 SCALE 1:2

DEO ATTACHED

RELEASED

d.09.19 *BS***D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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